

Work Order ID 124014

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124014

Page 1

Item ID: D350-636-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.
 Start Date: 9/05/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-09-05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750-041	G

100 Document Control 0.00
 100 DOCUMENT CONTROL

DC
 Doc.Control -USB or Paperwork

Memo
 record fwd angle: 89.6° DGC 0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

DAS
 86
 5-83

OCT 29 2014

MLJ

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
Skidtubes	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B)								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail A to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

DGL 14-9-11

DGL 14-9-19

DGL 14-9-11

DGL 14-9-19

8-24-09-19

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop *NS2*

Start Date: 9/05/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: M122399 7 BE14-09-19
9-Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds	0.00
---	------

120

QC

Memo	0.00
-------------	------

Quality Control

DAS
9
~~9-89~~

130

QC5- Inspect part completeness to step on W/O	0.00
---	------

130

QC

Memo	0.00
-------------	------

Quality Control

DAS
9
9-89

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Stop ***NS2***Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***


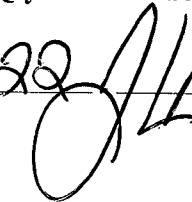
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

14-9-22  14-9-22

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Stop ***NS2***Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes using hole saw of Detail C and ground handling to 0.625"
(total of 8 holes per side)
as per dwg D2750.

2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole using un-bit to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per OSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch: 129457

exp. date: 14-11-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & OSI004
(welding instructions on sheet 8)

A/R Aluminum Rod

batch: m62399

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

14-9-24 JK

14-9-22 JK

14-9-23 JK

14-9-22

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								
	12-Deburr holes, ensure tube is free of all scratches before sending to paint.								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									DAS 9 9-89
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control	***VERIFY C'BOARD IS GOOD***								DAS 9 9-89

14-9-24

① 14-10-01

① 14-10-01

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Item ID: D350-636-011

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N900040100

Setup Start

NS1

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Stop

NS2

Start Date: 9/05/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/05/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

124 d 14/10/08

200

0.00

200

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2

PRIMER PRC DESOTO 515X349 BATCH: 128 975

2- PAINT WHITE AS PER DWG AND QSI 005 4.2

PAINT BATCH: 130 531

1 / 14/10/17

210

QC14- Inspect Spray Paint

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

124 d 14/10/21

DAS
15
9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D2750								
	2-Inspect for Foreign Objects								
	3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>11130227</u>								
	EXP DATE: <u>15/08</u>								
	4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>11129305</u> <u>1270598 BUK 11125792 exp 15/06</u>								
	5- Coat all exposed fasteners with "LPS Procyon" batch: <u>1122900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

DAS
38
9-80 14-10-22

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Item ID: D350-636-011

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N900040100

Setup Start

NS1

Revision ID:

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Stop

NS2

Start Date: 9/05/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

14

DAS
26
9-89

OCT 29 2014

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

DAS
03
9-89

OCT 29 2014

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

F6012

DAS
46
9-89

DAS
03
9-89

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Item ID: D350-636-011

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Stop ***NS2***Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

14/11/30

mf
14-10-30

Picklist Print

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Work Order ID: 124014

124014

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC IPP REV:R 13.08.27 PER ECN13-594 DD
 VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	121.0000	8	8			
D3492-1													
Plug													

Location

Loc Qty

Loc Code

FP001

121

B124026

111578

2

X8

114879

7

119646

2

120519

50

122460

60

D3492-3		Manufactured	No			230	Each	142.0000	8	8			
D3492-3													
Plug													

Location

Loc Qty

Loc Code

FP001

142

B124027

104853

24

X8

107331

1

112739

1

115807

6

118977

10

123464

100

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

383.0000

8

8

NAS1611-010

O-RING

ll 11/10/21

Location

Loc Qty

Loc Code

FP001

383

m126988

3

m127813

4

m128375

10

m129198

44

m129405

82

m129523

240

✓ 8

NAS1149D0863J

Purchased

No

250

Each

795.0000

2

2

NAS1149D0863.J

Washer

DAS
28
9-89

OCT 29 2014

Location

Loc Qty

Loc Code

ST276

595

118078

2

125268

586

125484

7

2x

ST2776

200

125635

200

D2744

Manufactured

No

110

Each

53.0000

1

1

D2744

Cap

BE 4-08-18

Location

Loc Qty

Loc Code

LG001

53

113128

52

115440

1

/

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D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

1.0000

1

1

D2600-3-BENT

Extrusion Bent

DGL 11-9-10

Location

Loc Qty

Loc Code

LG002

123609

1

119680

1

D2743

Manufactured No

160

Each

192.0000

8

8

D2743

Crossbolt Spacer

BE14-09-23

Location

Loc Qty

Loc Code

LG001

192

109799

1

122729

59

119609

58

120481

74

D2739

Manufactured No

160

Each

13.0000

1

1

D2739

350 I Beam

Location

Loc Qty

Loc Code

LG

10

123536

10

LG002

3

117245

2

117803

1

D3490-3

Manufactured No

160

Each

72.0000

4

4

D3490-3

Cross Bolt Spacer

BE14-09-23

Location

Loc Qty

Loc Code

LG

72

122458

22

122751

50

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Shop Packet Print

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Work Order ID: 124014

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D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

100.0000

4

4

D3490-1

Cross Bolt Spacer

08-14-09-23

Location

Loc Qty

Loc Code

LG

85

122457

85

LG001

15

112737

1

116358

14

Each

258.0000

38

11/10/21

ALS4-1032-225

AELS8-1032-225 Purchased No

ALS4-1032-225

*ALS4-1032-225

Rivnut

Location

Loc Qty

Loc Code

FG

30

M127028

30

1130565

ST267

228

M127028

10

M127092

26

M128179

192

230

Each

8.0000

1

1

11/10/21

D3793-3

Manufactured No

D3793-3

Wearplate Aft

Location

Loc Qty

Loc Code

FP001

1

M123333

104212

1

FP002

7

120141

7

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Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

73.0000

1

1

AN8C35A

Bolt

**

HL 10/10/20

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

69

m126293

29

m127823

1

m130114

39

X1

D3793-1

Manufactured

No

230

Each

11.0000

1

1

D3793-1

Wearplate Fwd

**

HL 10/10/20

Location

Loc Qty

Loc Code

FP002

11

B123366

112741

2

120212

8

92382

1

X1

D3488-041

Manufactured

No

230

Each

7.0000

1

1

D3488-041

Blade Fitting LH

**

HL 10/10/20

Location

Loc Qty

Loc Code

FP001

7

116834

6

88255

1

X1

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Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

11.0000

1

1

D3794-3

Gasket Aft

**

ll 10/10/21

Location

Loc Qty

Loc Code

FP001

11

111457

8

B124948

122529

2

92658

1

AN6C44A

Purchased

No

230

Each

45.0000

4

4

AN6C44A

Bolt

**

ll 10/10/21

Location

Loc Qty

Loc Code

FG

2

103964

2

11130665

ST333

43

m128319

2

m128700

1

m129199

40

MS21083C8

Purchased

No

230

Each

64.0000

1

1

MS21083C8

Nut

**

ll 10/10/21

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

x1

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Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

15.0000

1

1

D3536-25

Gasket Center

all 10/10/21

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

9

110652

1

123300

7

93696

1

B125637

XC

D3631-1

Manufactured No

230

Each

126.0000

8

8

D3631-1

Washer

all 10/10/21

Location

Loc Qty

Loc Code

FP001

126

110258

16

119553

10

123452

100

XC

D3791-1

Manufactured No

230

Each

6.0000

1

1

D3791-1

Wearpad

all 10/10/21

Location

Loc Qty

Loc Code

FP001

1

92689

1

FP002

5

118942

5

B120343

XC

Picklist Print

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Page 8

Work Order ID: 124014

124014

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

3,653.000

38

38

NAS1149C0332R

WASHER

all 11/10/20

Location

Loc Qty

Loc Code

CA

83

m129682

83

ST278

3570

122063

41

125654

609

m126319

61

m127306

2500

m127410

75

m127831

26

m128591

75

m129499

183

x38

D2745

Manufactured

No

230

Each

145.0000

8

8

D2745

Bushing

all 11/10/20

Location

Loc Qty

Loc Code

ST010

145

107336

4

113176

2

117099

7

119572

51

122643

73

90323

2

93336

6

x8

Picklist Print

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Page 9

Work Order ID: 124014

124014

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

140.0000

34

34

AN3C5A

Bolt

**

ell 11/10/21

Location

Loc Qty

Loc Code

FG

5

122800

5

M130358

x34

ST350

135

M128911

27

M128973

10

M129913

98

D3537-1

Manufactured

No

230

Each

93.0000

3

3

D3537-1

Wearpad

**

ell 11/10/21

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

B124485

x3

FP001

75

113839

4

120644

52

120645

18

93945

1

NAS1149C0832R

Purchased

No

230

Each

258.0000

1

1

NAS1149C0832R

Washer

**

ell 11/10/21

Location

Loc Qty

Loc Code

ST277

258

m114915

108

m125807

150

x1

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Page 9

Picklist Print

September-05-14 1:41:44 PM

Page 10

Work Order ID: 124014

124014

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

1,058.000

4

4

AN3C6A

Bolt

ll 11/10/21

Location

Loc Qty

Loc Code

FG

10

122416

10

ST513

1048

m125709

52

m128769

996

VI

NAS1611-013

Purchased

No

230

Each

140.0000

8

8

NAS1611-013

O-RING

ll 11/10/21

Location

Loc Qty

Loc Code

FP001

140

m128375

72

m129430

68

1130358

x 8

D3535-25

Manufactured

No

230

Each

24.0000

1

1

D3535-25

Wearplate Center

ll 12/10/21

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

22

110744

1

123415

20

93278

1

XI

Picklist Print

September-05-14 1:41:44 PM

Page 11

Work Order ID: 124014

124014

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

2.0000

1

1

D3794-1

Gasket Fwd

Handwritten: ul 10/12/14

Location

Loc Qty

Loc Code

FP001

2

Handwritten: B124082

Handwritten: x1

109207

1

93381

1

MS21043-6

Purchased No

230

Each

58.0000

4

4

MS21043-6

NUT

Handwritten: ul 10/12/14

Location

Loc Qty

Loc Code

FG

20

Handwritten: 11130325

Handwritten: x4

103693

20

ST306

38

m127255

6

m127813

32

D3493-1

Manufactured No

250

Each

139.0000

2

2

D3493-1

Washer

DAS
26
9-89

Handwritten: OCT 7 9 2014

*Handwritten: DAS
26
9-89*

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

129

109105

129

Handwritten: 2x

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

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Page 12

Work Order ID: 124014

124014

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

250

Each

64.0000

2

MS21083C8

Nut

**

m130358

OCT 29 2014

DAS
03
9-89

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

AN8C21A

Purchased No

250

Each

62.0000

2

AN8C21A

Bolt

**

DAS
26
9-89

OCT 29 2014

DAS
03
9-89

Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

60

m127061

2

m127823

3

m129888

55

NAS1515H3L

Purchased No

230

Each

293.0000

4

***NAS1515H3L ***

Washer

**

all 10/10/20

Location

Loc Qty

Loc Code

FG

40

102472

40

ST273

253

m127831

136

m128976

117

X4

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Page 13

Work Order ID: 124014

124014

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

48.0000

1

1

D2741

Blade

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

10

100664

5

113640

2

115522

3

ST538

38

118387

38

D3532-1

Manufactured No

250

Each

34.0000

2

2

D3532-1

Spacer

DAS
26
9-89

OCT 29 2014

Location

Loc Qty

Loc Code

ST048

34

115855

3

117198

3

122723

21

123513

7

DAS
63
9-89

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH; ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (\varnothing 0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER

NO 124014 MLO

14-09-05

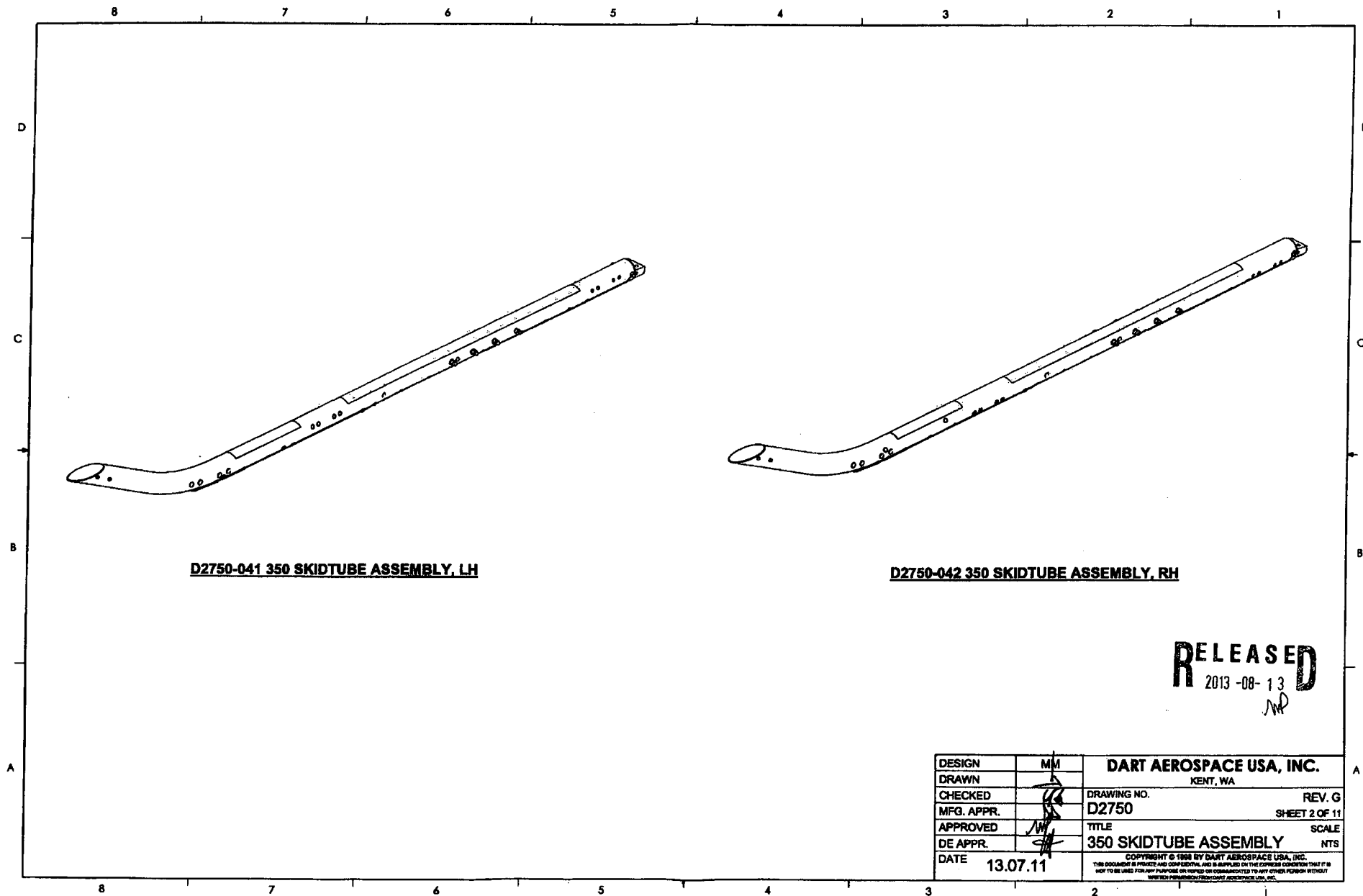
RELEASED
2013-08-13
WD

G	CORRECTED TOLERANCE ON \varnothing 0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1, A-5, G-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.
KENT, WA

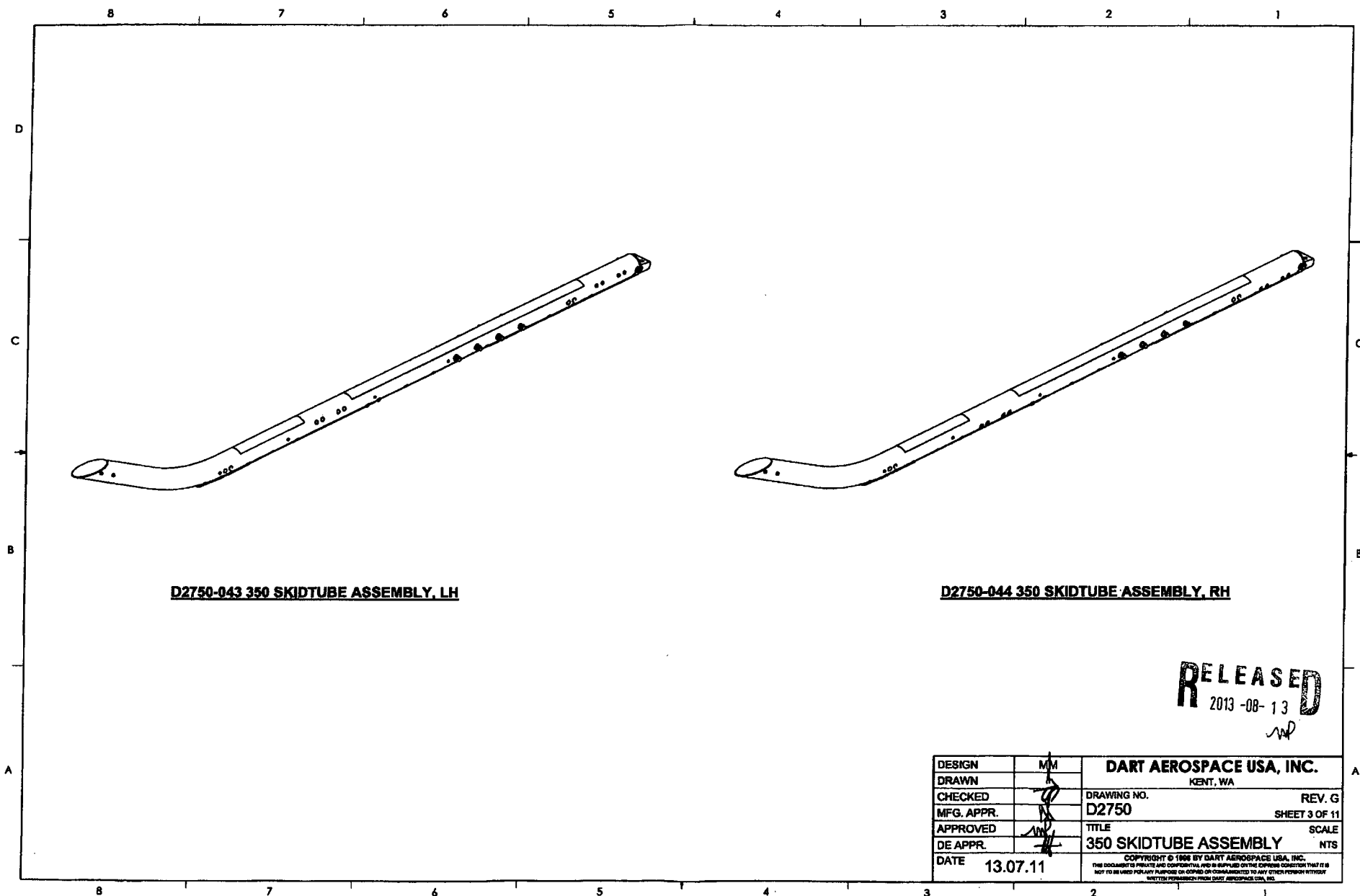
DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
REV. G
SHEET 1 OF 11
SCALE
NTS

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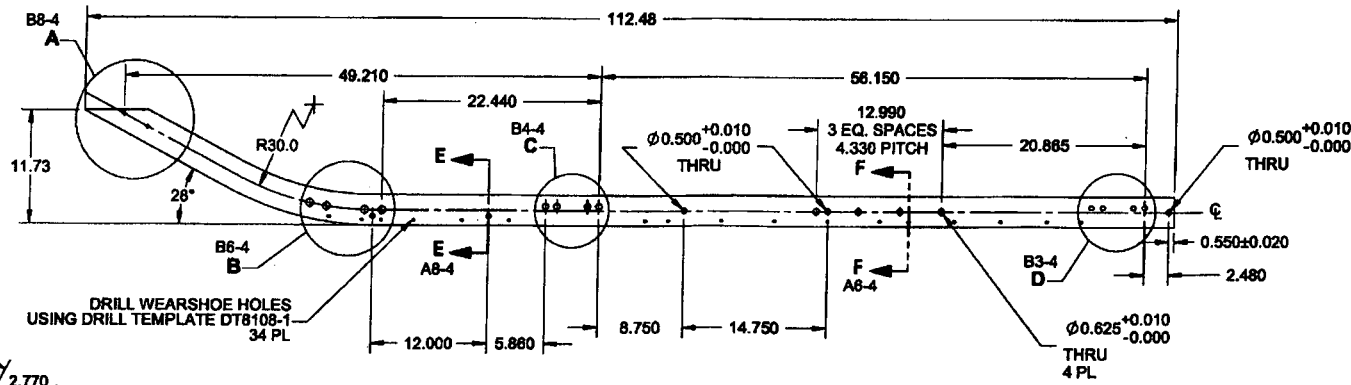
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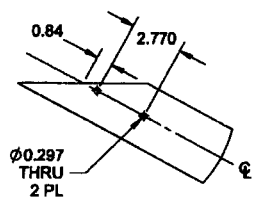
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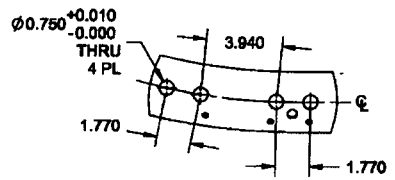
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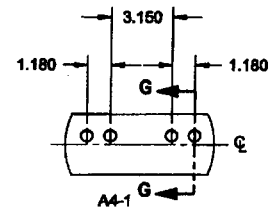
D2750-1 LH SKIDTUBE



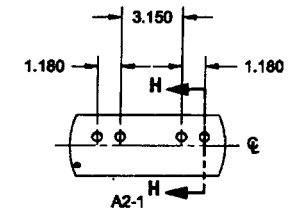
DETAIL A
SCALE 2X
D7-4



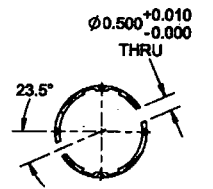
DETAIL B
SCALE 2X
D7-4



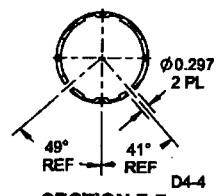
DETAIL C
SCALE 2X
D5-4



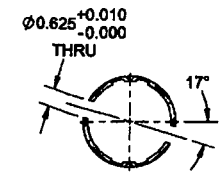
DETAIL D
SCALE 2X
D3-4



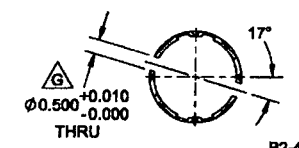
SECTION E-E
SCALE 3X, 2 PL
D6-4



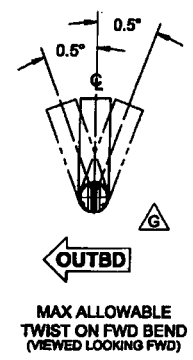
SECTION F-F
SCALE 3X, 17 PL
D4-4



SECTION G-G
SCALE 3X, 4 PL
B4-4



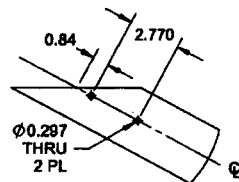
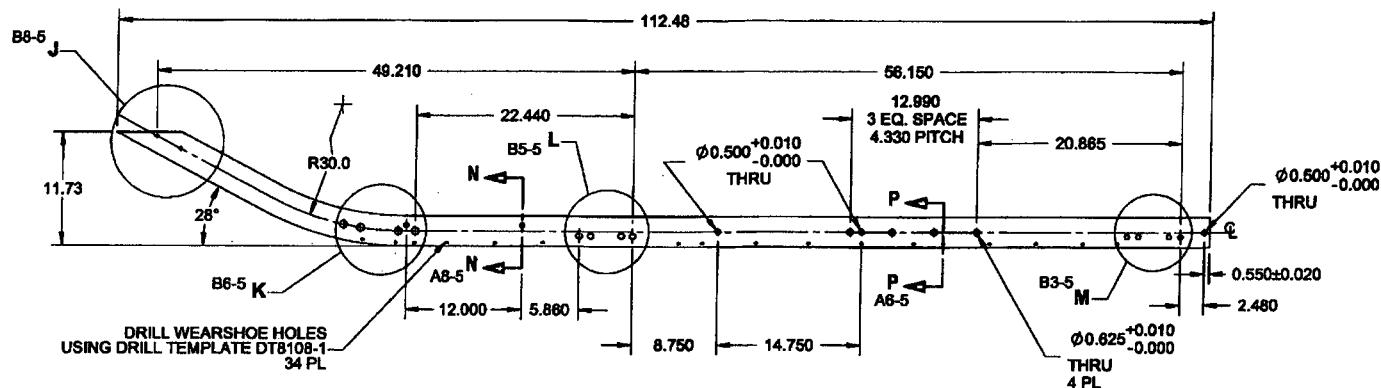
SECTION H-H
SCALE 3X, 4 PL
B2-4



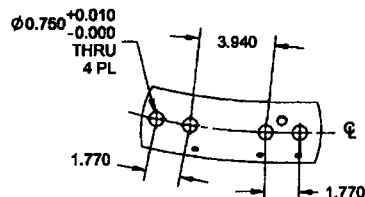
MAX ALLOWABLE TWIST ON FWD BEND
(VIEWED LOOKING FWD)

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2013-08-13
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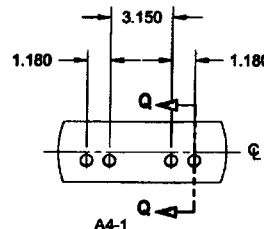
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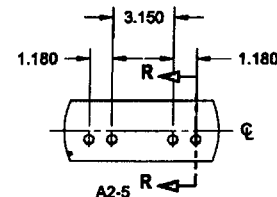
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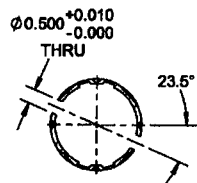
C7-5
SCALE 2X



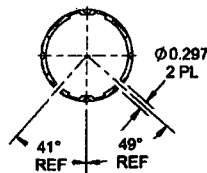
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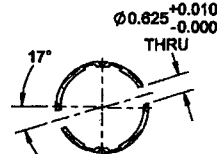
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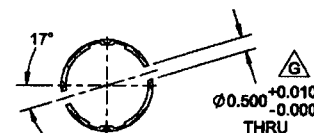
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C4-5



B5-5



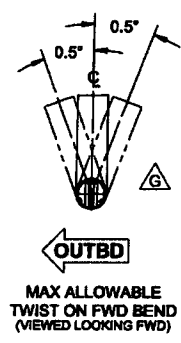
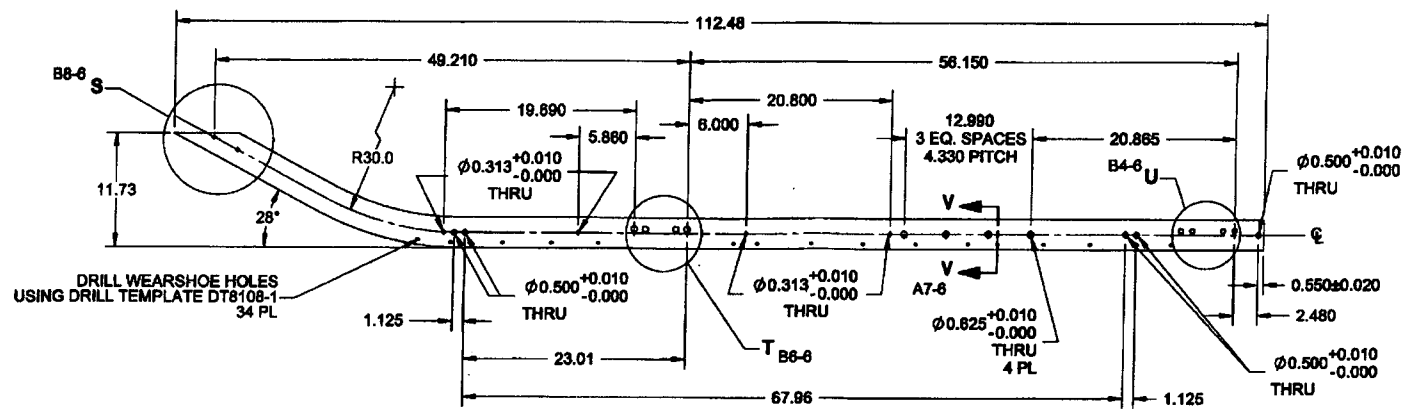
B3-5

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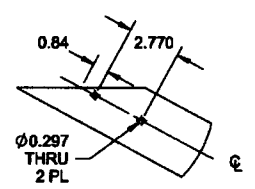
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TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
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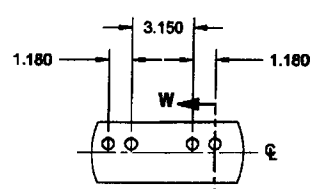
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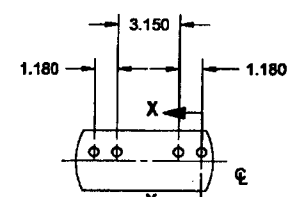
D2750-3 LH SKIDTUBE



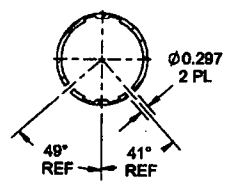
DETAIL S
D8-6
SCALE 2X



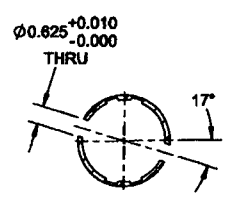
DETAIL T
C5-6
SCALE 2X



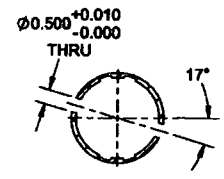
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL

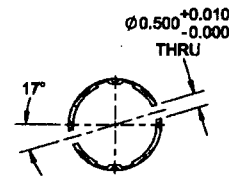
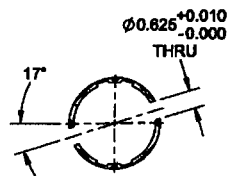
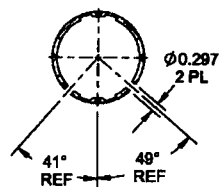
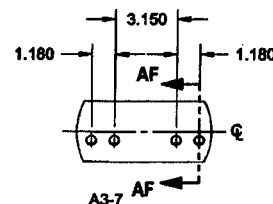
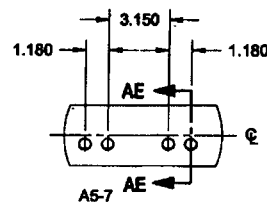
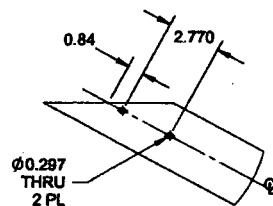
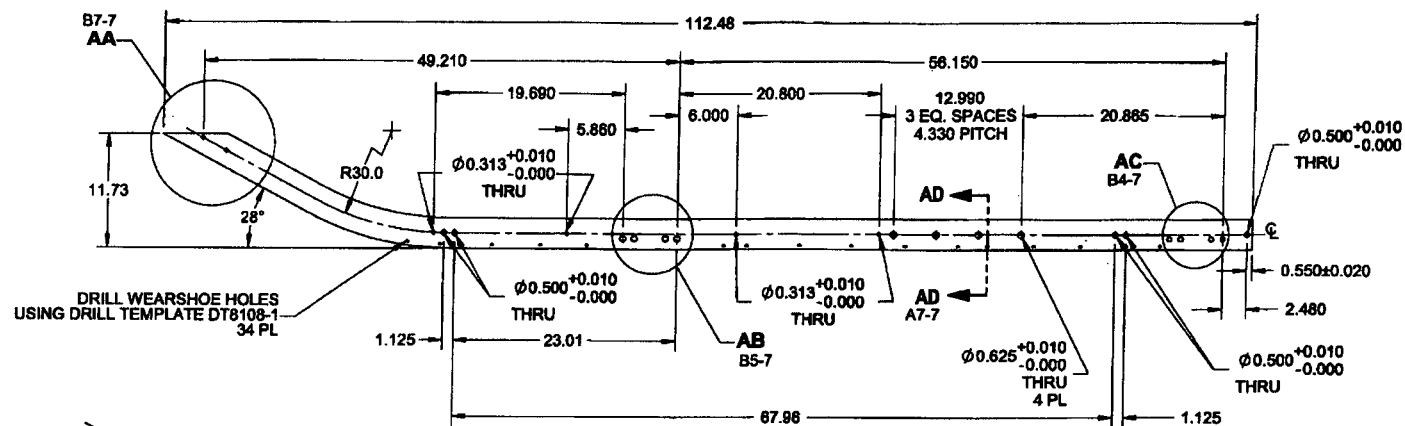


SECTION X-X
B4-6
SCALE 3X, 4 PL

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2013-08-13

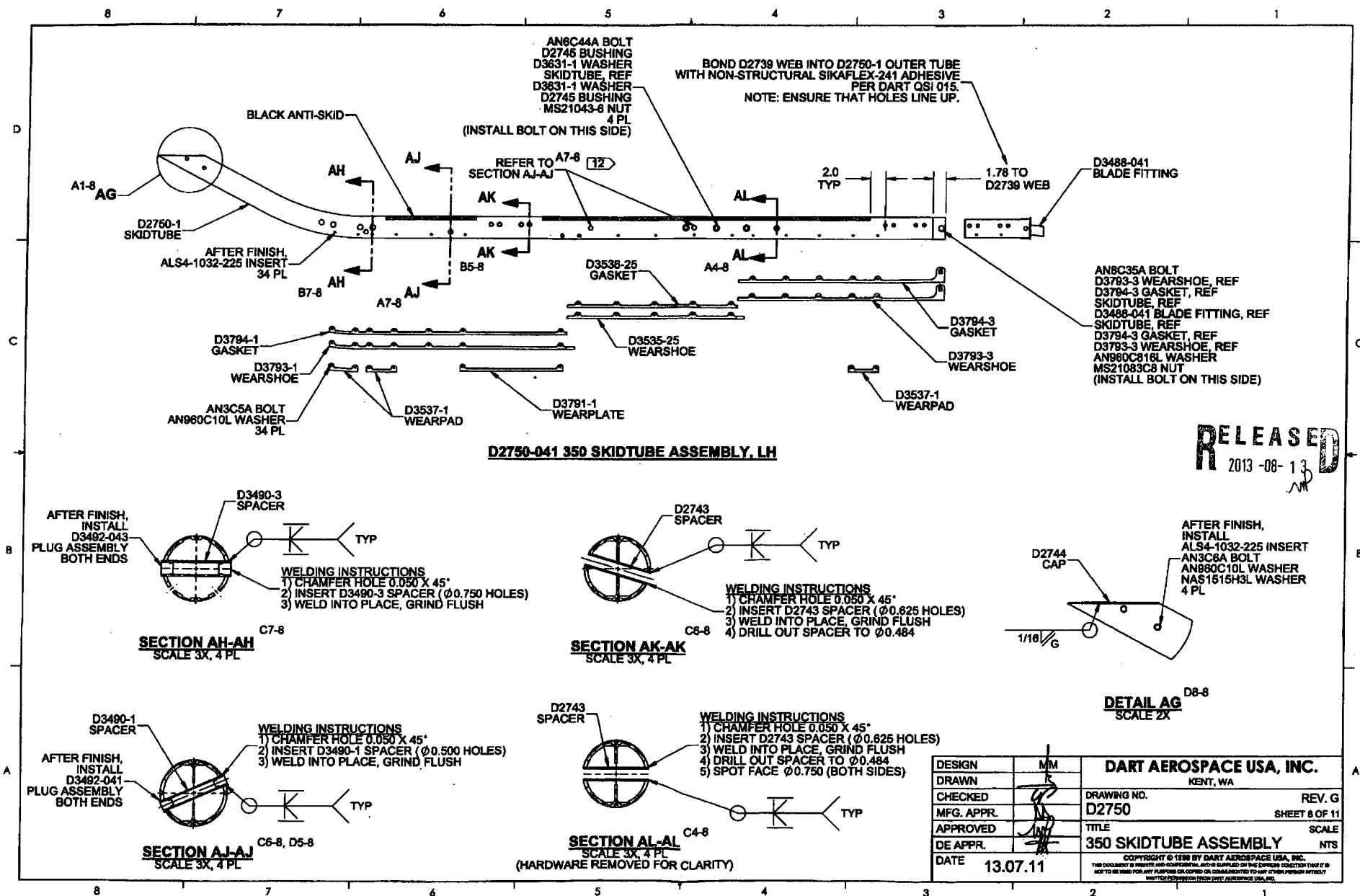
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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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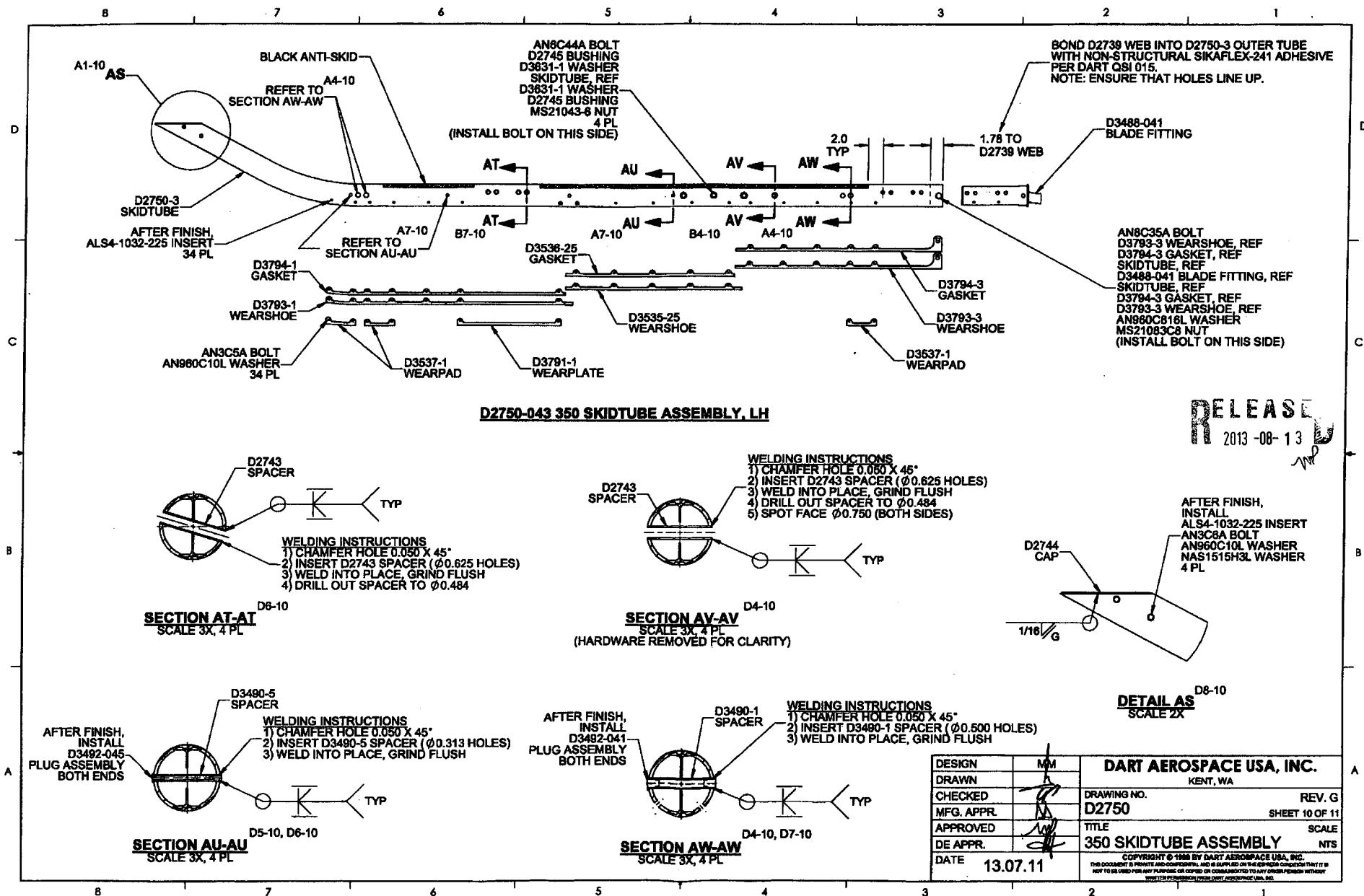
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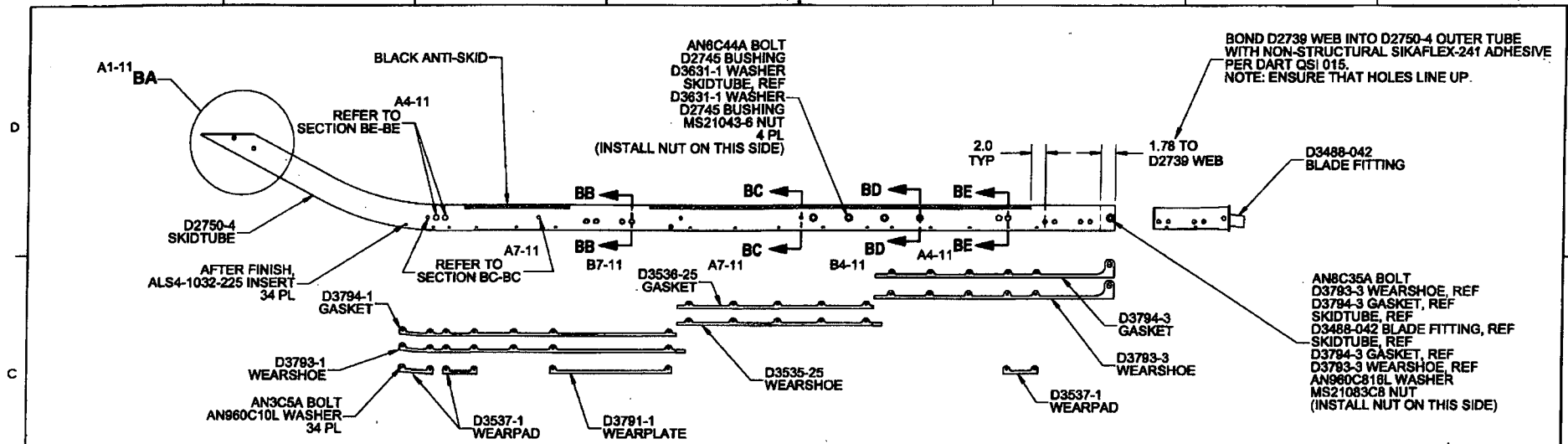
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2013-08-13

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DRAWN		KENT, WA
CHECKED		DRAWING NO. D2750
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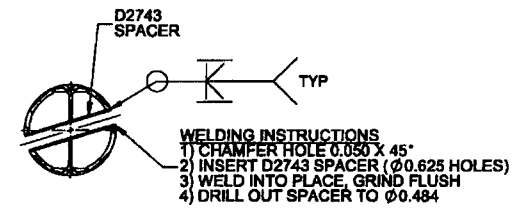




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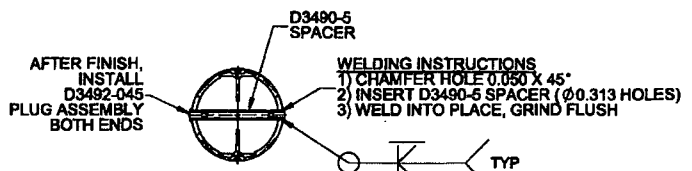
D2750-044 350 SKIDTUBE ASSEMBLY, RH



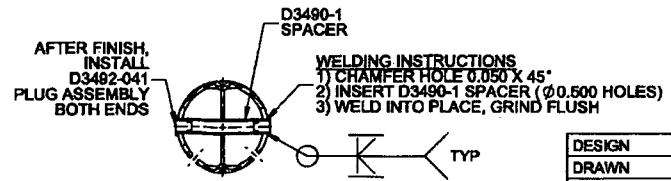
SECTION BB-BB
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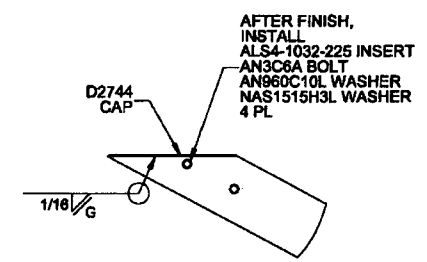
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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